

Work Order ID 73507

Thursday, September 01, 2011 12:40:21 PM



Page 1

Item ID: D3997-5

Accept



Setup Start



Revision ID:

Item Name: Placard

Stop



Start Date: 9/1/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 9/8/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3997

A

100

0.00



Purchasing

Memo

0.00

Purchasing

Issue P/O: 14813
Manufacture as per Dwg D3997
Possible Supplier: Studio Lettrage
Material release note required

CZ 11/09/02 10

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

P4/9/12 (10)

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

8 4/02/12

(710)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73507

Page 2

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Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: ST 104

0.00



Packaging

Memo

0.00

Packaging

(10x) Sp 11-09-13.

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/13

11-09-13
(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, September 01, 2011 12:40:18 PM

Page 1

Work Order ID: 73507

Parent Item: D3997-5

Parent Item Name: Placard




Start Date: 9/1/2011

Required Date: 9/8/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP rev A 10.01.12 new issue Prelim EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3997-5P  Placard		Purchased	No				Each	90.0000		10		9/1/12	GS

Location

Loc Qty

Loc Code

ST

90

72611

90

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

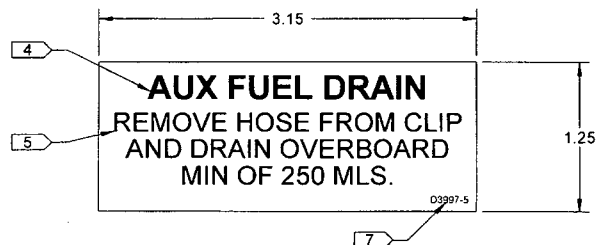
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

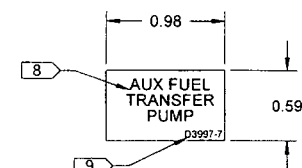
NOTE: Date & initial all entries

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D3997-5	JCA-M47-P3
D3997-7	JCA-M47-P4
D3997-9	JCA-M47-P5
D3997-11	JCA-M47-P6

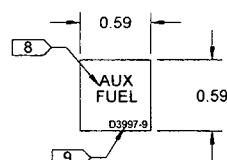
PART NUMBER	INSTALLATION INSTRUCTIONS
D3997-5	ON TANK ADJACENT TO FUEL DRAIN
D3997-7	ADJACENT TO PUMP SWITCH ON INSTRUMENT PANEL
D3997-9	IN AIRCRAFT SWITCH PANEL
D3997-11	ON TANK OUTBOARD SURFACE



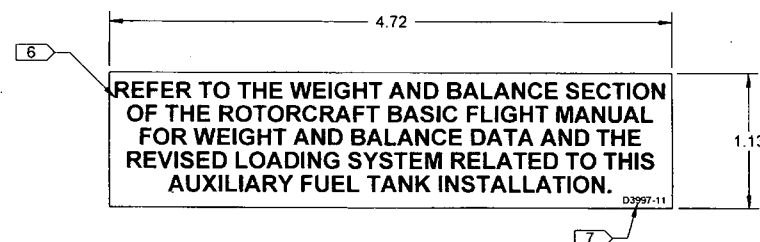
D3997-5 PLACARD



D3997-7 PLACARD



D3997-9 PLACARD



D3997-11 PLACARD

RELEASED
2010-01-11
MP

- NOTES:**
- 1) MATERIAL: 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031
 - 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 3) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 4) 20 PT FONT, BLACK TEXT ON WHITE BACKGROUND
 - 5) 16 PT FONT, BLACK TEXT ON WHITE BACKGROUND
 - 6) 14 PT BOLD FONT, BLACK TEXT ON WHITE BACKGROUND
 - 7) 6 PT FONT, BLACK TEXT ON WHITE BACKGROUND
 - 8) 10 PT FONT, WHITE TEXT ON BLACK BACKGROUND
 - 9) 6 PT FONT, WHITE TEXT ON BLACK BACKGROUND

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3997	REV. A
MFG. APPR.			SHEET 2 OF 6
APPROVED		TITLE PLACARD	SCALE
DE APPR.			NTS
DATE	09.10.05	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Product & Instruction Bulletin 8522

Release I, Effective September 2008

See Bulletin Change Summary and end of Bulletin

This Bulletin now includes Instruction Bulletin 4.23

Scotchcal™ Changeable Opaque Imaging Media 8522

Product Description

For Thermal Inkjet Printing

This durable, 7 mil, opaque, changeable film is optimized for use with selected thermal inkjet printers and inks. Ink dries quickly on the film. When overlaminated, it is warranted for medium term, outdoor weatherable graphics, and long term indoor graphics.

Recommended Types of Graphics and End Uses

When constructed and used as described in this Bulletin, these types of graphics and end uses may be warranted by the 3M™ MCS™ Warranty. Please read the entire Bulletin for details.

- First surface images (the image is on top of the film) for opaque posters and signs, including:
 - Graphics for vans, personal vehicles, trucks and buses
 - Novelty posters
 - Retail and point-of-purchase displays
 - Information graphics such as maps and directories
 - Entertainment promotions in museums, zoos, parks, theatres, sports venues
 - Education and presentation graphics
 - Legal and courtroom exhibits
- For flat or simple curved surfaces, with or without rivets, used in vertical ($\pm 10^\circ$) applications

Limitations of End Uses

3M specifically does not recommend or warrant the following uses, but please contact us to discuss your needs or recommend other products.

Unsuitable End Uses for This Product

- Not for electronically cut individual letters and numbers
- Fleet applications in areas that use salt for winter road maintenance
- Application to non-warranted substrates, including wallboard
- Applications subjected to gasoline vapors or spills
- Application to corrugated or highly irregular surfaces or sharply raised areas
- Graphics applied to stainless steel, including stainless steel vehicles
- On flat surfaces with rivets, tenting of 4 to 10 mm around rivets may be expected; rivets may be cut around to eliminate tenting.
- Graphics made for automotive Original Equipment Manufacturers (OEM); contact 3M Automotive Division at 1-800-328-1684 for alternatives.

About Water-Based Inkjet Technology

Standard inkjet technology is water based. Water-based chemistry is susceptible to the extremes of heat and humidity. This is a factor in most product constructions on the market. Read the Fabrication, Shelf Life and Storage sections in this Bulletin. Staying in the middle of these ranges always provides optimum performance.

Characteristic	Description
Warranted application substrates	<p>Some substrates may "out-gas", resulting in tiny bubbles throughout the surface of the graphic. For maximum performance, be sure the substrate you select is properly cleaned and prepared as recommended by the manufacturer. See Instruction Bulletin 5.1 for additional information.</p> <ul style="list-style-type: none"> • Alodine (anodized aluminum) • Automotive panels (automotive painted steel) • Fruehauf (painted aluminum) • FRP (fiberglass reinforced plywood) • Glass • Imron® (polyurethane-painted metal panel) • Acrylic • Sintra™ board <p>Note: Use on any other substrate is strictly on a graphics manufacturer and customer test and approve basis. Test for both adhesion and removal characteristics. The plasticizer in some banner materials may migrate. This may cause the edge of the graphic to peel or lift off of the banner. For optimum performance, follow the guidelines in the section, Creating A Laminated Overlap, on page 4.</p>

Warranty Information

The warranty given in the Product Bulletin that is current at the time you purchased the film is the one that 3M will honor. **The warranties in the following table(s), given in years, are for finished graphics exposed in a vertical exposure in the United States except the Desert Southwest.** See the warranty sections following this table for additional information.

3M™ MCST™ Warranty Durability for Finished Graphics

Construction (film and overlamine on warranted substrate)	HP Printers & Inks		Epson Printers & Inks		Removal
	Outdoor	Indoor	Outdoor	Indoor	
8522/8519	3 years	5 years	2 years	5 years	1 year without chemical strippers or tools
8522/8520					

Warranty and Limited Remedy

The following is made in lieu of all other express or implied warranties, including any implied warranty of **merchantability** or fitness for a particular purpose or implied warranty arising out of a course of dealing, custom or usage of trade: all 3M products are warranted to be free of defects in materials and manufacture at the time of shipment and to meet the specifications stated in this Product Bulletin. 3M will replace or refund the price of any 3M materials that do not meet this warranty within the specified time periods. These remedies are exclusive. **In no case shall 3M be liable for any direct, indirect, or consequential damages, including any labor or non-3M materials charges.**

See the Graphics Market Center Warranty Brochure, which gives the terms, additional limitations of the warranty, if any, and limitations of liability.

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO14813**

Purchase Order Date 9/2/2011

PO Print Date 9/2/2011

Page Number 1 of 2

Order From :

VC-STU001

STUDIO DE LETTRAGE 2001
210 MAIN WEST
HAWKESBURY, ON K6A 2H6
CA

Contact Name

Vendor Phone 613 632 5449

Vendor Fax 613 632 9491

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr 10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Chantal Lavoie

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D3428-1P	Placard	9/9/2011 Yes	20.00 Each	Yours ppd	\$5.0000	\$100.00
		Special Inst:	AS PER DWG D3428 REV. A B73498				
2	D3997-1P	Placard	9/9/2011 Yes	10.00 Each	Yours ppd	\$5.0000	\$50.00
		Special Inst:	AS PER DWG D3997 REV. A B73509				
3	D3997-5P	Placard	9/9/2011 Yes	10.00 Each	Yours ppd	\$5.0000	\$50.00
		Special Inst:	AS PER DWG D3997 REV. A B73507				
4	D3997-11P	Placard	9/9/2011 Yes	10.00 Each	Yours ppd	\$5.0000	\$50.00

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 1

Change Date: 9/2/2011



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO14813

Purchase Order Date 9/2/2011

PO Print Date 9/2/2011

Page Number 2 of 2

Order From :

VC-STU001

STUDIO DE LETTRAGE 2001
210 MAIN WEST
HAWKESBURY, ON K6A 2H6
CA

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	613 632 5449	Requisition Nbr	
Vendor Fax	613 632 9491	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	Destination-Collect

Special Inst: AS PER DWG D3997 REV. A
B73510

5	D3997-17P	Placard	9/9/2011	10.00	Yours ppd	\$5.0000	\$50.00
			Yes	Each			

Special Inst: AS PER DWG D3997 REV. A
B73513

6	D3997-25P	Placard	9/9/2011	10.00	Yours ppd	\$5.0000	\$50.00
			Yes	Each			

Special Inst: AS PER DWG D3997 REV. A
B73506

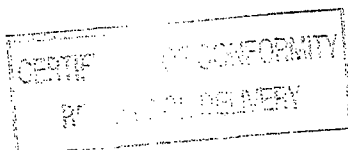
7	D3997-29P	Placard	9/9/2011	10.00	Yours ppd	\$5.0000	\$50.00
			Yes	Each			

Special Inst: AS PER DWG D3997 REV. A
B73511

8	D3997-43P	Placard	9/9/2011	10.00	Yours ppd	\$5.0000	\$50.00
			Yes	Each			

Special Inst: AS PER DWG D3997 REV. A
B73512

PO Total: \$450.00



h c2

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 1

Change Date: 9/2/2011

Studio de Lettrage

210 Main Street W
Hawkesbury, Ontario K6A 2H6

INVOICE

Invoice No.: 16342
Date: 09/12/2011
Ship Date:
Page: 1
Re: Order No. 11440

Sold to:

Dart Aerospace Ltd
1270 Aberdeen
Hawkesbury, Ontario
K6A 1K7

Ship to:

Dart Aerospace Ltd
Hawkesbury, Ontario

Business No.: 82500 7651 RT0001

Item No.	Unit	Quantity	Description	Tax	Unit Price	Amount
		20	D3428-1P set up	H	2.50	50.00
		10	D3997-1P set up	H	5.00	50.00
		10	D3997-5P set up <i>See log 1, 2</i>	H	5.00	50.00
		10	D3997-11P set up	H	5.00	50.00
		10	D3997-17P set up	H	5.00	50.00
		10	D3997-25P set up	H	5.00	50.00
		10	D3997-29P set up	H	5.00	50.00
		10	D3997-43P set up	H	5.00	50.00
		1	printing	H	175.00	175.00
			H - HST 13%			
			HST			74.75
			PST Exempt: #6122-5207			
Studio de Lettrage HST: #869034678RP001						
Shipped By: Tracking Number:						
Comment: PO 14813						
Sold By:						
Total Amount						649.75